

METHOD FOR INJECTION-MOLDING SEMISOLID METAL AND APPARATUS THEREFOR

Patent Number: JP9108805
Publication date: 1997-04-28
Inventor(s): SAKAMOTO KAZUYA;; HAMAZOE NORIMASA;; SUGANUMA HIROMITSU;; SUZUKI ATSUSHI
Applicant(s): HONDA MOTOR CO LTD
Requested Patent: ☐ JP9108805
Application Number: JP19950268398 19951017
Priority Number(s):
IPC Classification: B22D17/00; B22D17/20; B22D17/30
EC Classification:
Equivalents:

Abstract

PROBLEM TO BE SOLVED: To remove the air and gas and to provide an injection molded body without blow hole by injection-molding while inclining an injection molding machine at a prescribed angle upward while using the tip part thereof as the inclining center.

SOLUTION: A cylinder unit 13 is extended in the horizontal state of an injection cylinder 17 and a nozzle member 18 at the tip part of the cylinder 17 is separated from a metallic mold 40. Ball screws 3, 7 are worked to incline the cylinder 17 and the cylinder unit 12 is worked in the shrinking direction and the nozzle member 18 is abutted on the metallic mold 40. The gas mixed in metallic slurry in the cylinder 17 is shifted upward with the action of gravity and removed to the outer part from a material supporting chamber 24. A screw shaft 21 is advanced with a plunger cylinder 23 and the metallic slurry is injected into the metallic mold 40 to obtain the molded body. Since the gas is not mixed in the slurry, the weighing of the material is accurately executed and it is prevented that the material is infiltrated to the rear part of the shaft 21.

Data supplied from the esp@cenet database - I2